

Date: Thursday, 9/14/2006 7:28:37 AM  
 User: Kim Johnston

## Process Sheet

|  |   |
|--|---|
| <b>Customer</b> : CU-DAR001 Dart Helicopters Services  | <b>Drawing Name</b> : SHUT-OFF VALVE SHAFT                |
| <b>Job Number</b> : 28557                              |   |
| <b>Estimate Number</b> : 12193                         |   |
| <b>P.O. Number</b> : N/A                               | <b>Part Number</b> : D3470041                             |
| <b>This Issue</b> : 9/14/2006 <b>S.O. No.</b> : N/A    | <b>Drawing Number</b> : D3470 REV.A                       |
| <b>Prsht Rev.</b> : NC                                 | <b>Project Number</b> : N/A                               |
| <b>First Issue</b> : N/A <b>Type</b> : PURCHASED PARTS | <b>Drawing Revision</b> : A                               |
| <b>Previous Run</b> : 26986                            | <b>Material</b> : N/A                                     |
| <b>Written By</b> : <u>HA 06 09 14</u>                 | <b>Due Date</b> : 10/5/2006 <b>Qty:</b> 4 <b>Um:</b> Each |
| <b>Checked &amp; Approved By</b> : <u>HA 06 09 14</u>  |   |
| <b>Comment</b> : est rev A 06.04.20 new issue EC       |   |

## Additional Product

Job Number:



|                |                              |                      |
|----------------|------------------------------|----------------------|
| <b>Seq. #:</b> | <b>Machine Or Operation:</b> | <b>Description :</b> |
|----------------|------------------------------|----------------------|

|     |        |     |
|-----|--------|-----|
| 1.0 | D34703 | ARM |
|-----|--------|-----|



**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

|     |             |             |        |
|-----|-------------|-------------|--------|
| Qty | Part number | Description | batch  |
| 1   | D3470-3     | ARM         | B26115 |

HA 06/10/05 (4)

|     |        |       |
|-----|--------|-------|
| 2.0 | D34701 | SHAFT |
|-----|--------|-------|



**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

|     |             |             |        |
|-----|-------------|-------------|--------|
| Qty | Part number | Description | batch  |
| 1   | D3470-1     | Shaft       | B27014 |

HA 06/10/05 (4)

|     |             |                              |
|-----|-------------|------------------------------|
| 3.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 |
|-----|-------------|------------------------------|



**Comment:** LARGE FABRICATION RESOURCE 1

Weld assembly as per dwg D3470

HA 06/10/05 (4)

|     |       |                 |
|-----|-------|-----------------|
| 4.0 | QC5/9 | WELD INSPECTION |
|-----|-------|-----------------|



**Comment:** WELD INSPECTION

PD 06-10-DS (4)

|     |             |                       |
|-----|-------------|-----------------------|
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: S7441

PD 10/16 (4)

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: PD Date: 06/10/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Thursday, 9/14/2006 7:28:38 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHUT-OFF VALVE SHAFT

Job Number: 28557

Part Number: D3470041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(H)

Comment: FINAL INSPECTION/W/O RELEASE

SD 06/10/06

Job Completion



u 06/10/06

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

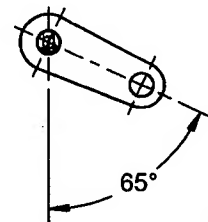
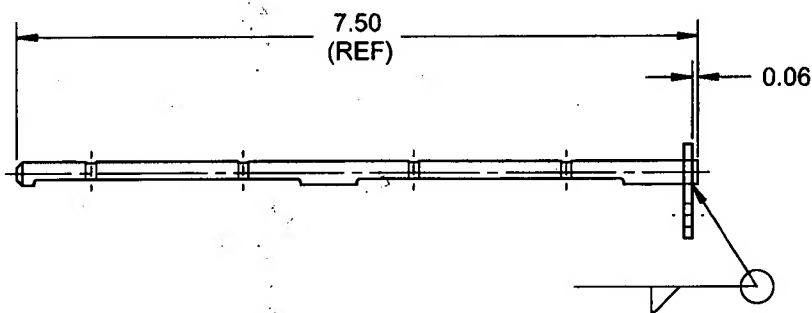
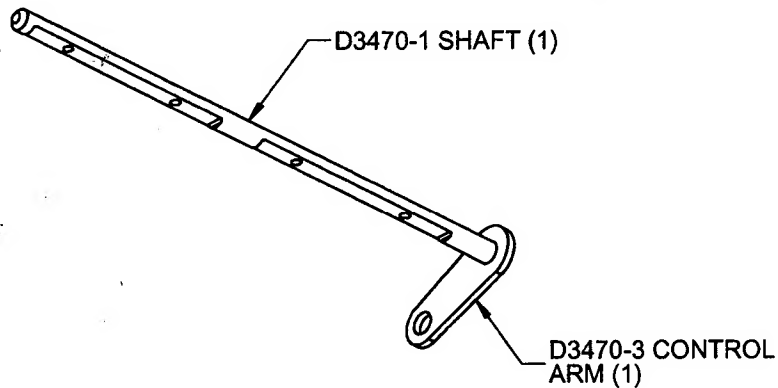
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



|                               |                                |   |                        |
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| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D3470                              | REV. A<br>SHEET 1 OF 4 |
| DATE<br>05.12.14              |                                | TITLE<br>SHUT-OFF VALVE SHAFT                     | SCALE<br>1:2           |
| A                             | 05.12.14                       | NEW ISSUE   |                        |



### D3470-041 SHUT-OFF VALVE SHAFT

#### NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

| QTY<br>-041 | P/N       | DESCRIPTION          |
|-------------|-----------|----------------------|
| X           | D3470-041 | SHUT-OFF VALVE SHAFT |
| 1           | D3470-1   | SHAFT                |
| 1           | D3470-3   | CONTROL ARM          |

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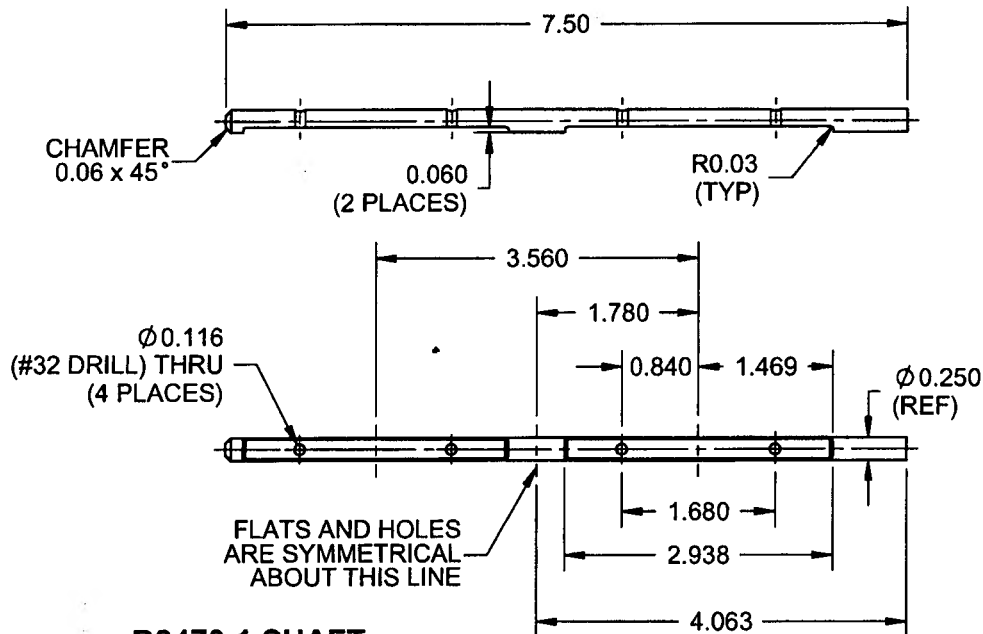
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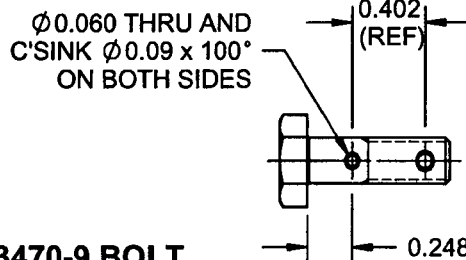


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| DATE<br><b>05.12.14</b>       |                                | TITLE<br><b>SHUT-OFF VALVE SHAFT</b>                     | SCALE<br>1:2           |

**D3470-1 SHAFT**

- 1) MATERIAL: AISI 303 STAINLESS STEEL 0.25 ROUND BAR  
(REF. DART SPEC. M303R0.250)

**D3470-9 BOLT**

SCALE 1:1

- 1) MAKE FROM AN4-6 BOLT

**NOTES:**

- 2) FINISH: NONE  
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES  
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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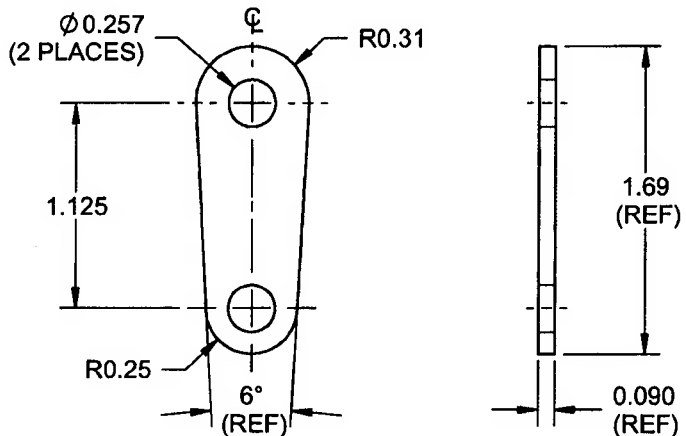


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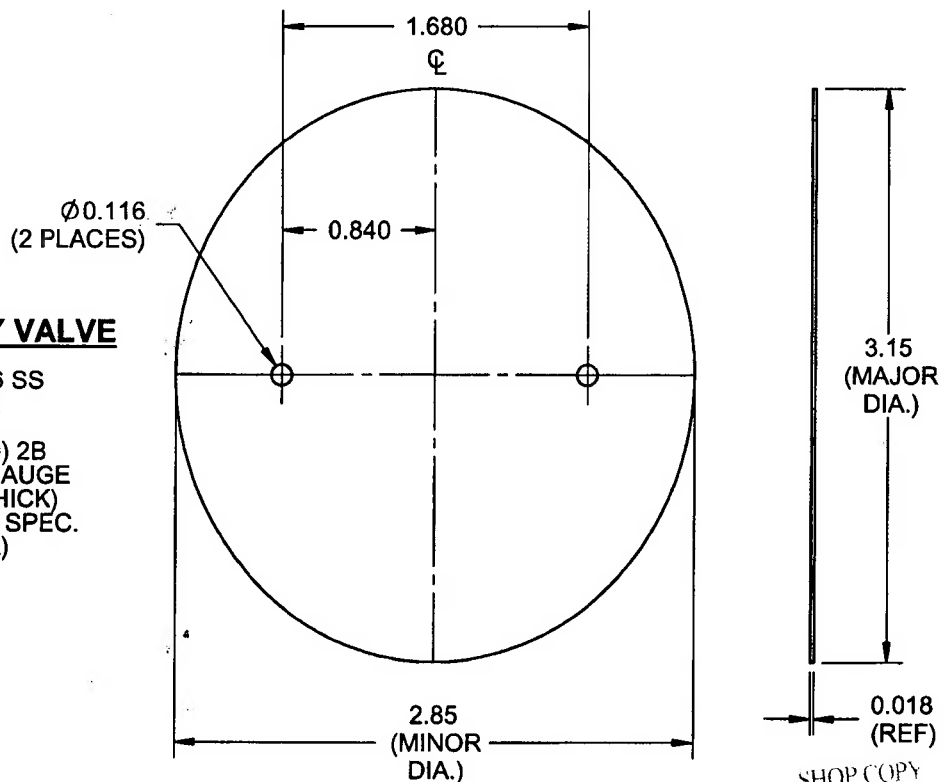
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| DATE<br><b>05.12.14</b> |               | TITLE<br><b>SHUT-OFF VALVE SHAFT</b>                     | SCALE<br>1:1           |

**D3470-3 CONTROL ARM**

- 1) MATERIAL: AISI 304/316 SS SHEET PER  
MIL-S-5019 (ANNEALED) 2B  
FINISH 13 GAUGE SS  
(0.090 THICK)  
(REF. DART SPEC. M304S13GA)

**D3470-5 BUTTERFLY VALVE**

- 1) MATERIAL: AISI 304/316 SS  
SHEET PER  
MIL-S-5019  
(ANNEALED) 2B  
FINISH 26 GAUGE  
SS (0.018 THICK)  
(REF. DART SPEC.  
M304S26GA)

**NOTES:**

- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

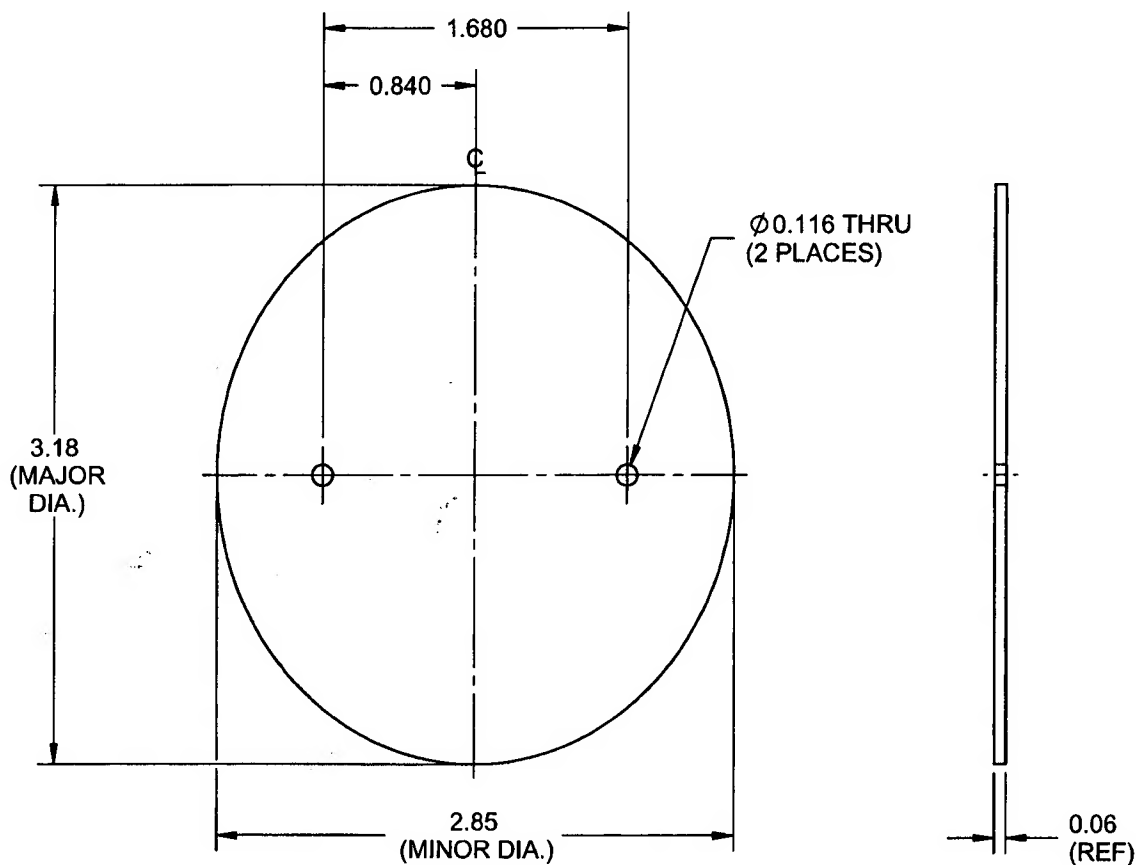
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| DATE<br><b>05.12.14</b>       |                                | TITLE<br><b>SHUT-OFF VALVE SHAFT</b>                     | SCALE<br>1:1           |

**D3470-7 BUTTERFLY VALVE SEAL****NOTES:**

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.063 THICK (REF. DART SPEC. M-SIL60-S.063)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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